

Date: Thursday, 4/12/2007 9:33:33 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	PACKER
Job Number	31783		
Estimate Number	10225		
P.O. Number	N/A	Part Number	D2150
This Issue	4/12/2007	Drawing Number	D2150 REV. A
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	A
Previous Run	29837	Material	N/A
Written By		Due Date	4/28/2007
Checked & Approved By	07.04.12	Qty:	20
Comment	Est C 00.11.27 Re-format (mpp 2101) EC Est Rev:D 06-08-23 Now on Waterjet	Um:	Each
JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M2024T3S040	2024-T3 .040 sheet	
Comment: Qty.: 0.0263 sf(s)/Unit Total : 0.5250 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>M104025</u> <u>SAD</u> <u>07/05/08</u>			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D2150 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>2-Deburr if necessary</u> <u>SAD</u> <u>07/05/08 20</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD</u> <u>07/05/08</u> <u>(20)</u>			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK <u>07/05/08 20</u>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>ml07/05/08</u> <u>x20</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:33 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PACKER

Job Number: 31783

Part Number: D2150

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL

07/05/09 60

7.0 POWDER COATING



POWDER COATING

M 103706



Q0X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f

07/05/09

8.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

07/05/09

60

9.0 PACKAGING 1



PACKAGING RESOURCE #1

Identify and Stock

Location: *etc/*

07/05/10 60



60

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/10

U 07.05.10

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31783
Description: Packer	Part Number:	D2150
Inspection Dwg: D2150	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD
Date:	07/05/08

Audited by: AA

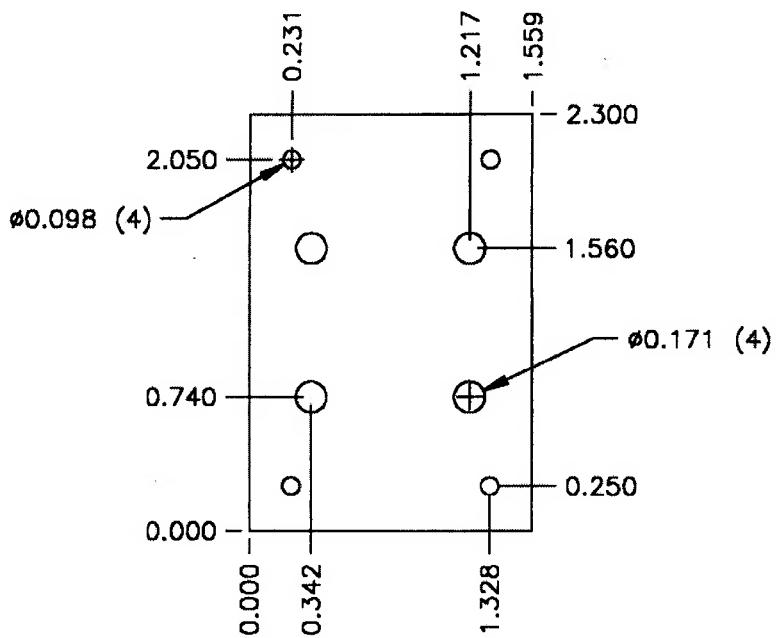
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.28	New Issue	KJ/JLM	

DART

COPY ISSUE

DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
CHECKED B.W.	APPROVED B.W.	DRAWING NO. D2150	REV. A	SHEET 1 OF 1
DATE 95:05:01		TITLE PACKER	SCALE 1:1	

RELEASED
96/06/13 B.W.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31783

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS